

Work Order ID 104748

\*104748\*

Page 1

July-17-13 2:36:19 PM

Item ID: D205-634-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 7/17/13 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/17/13 Req'd Qty: 2.00

\*2\*

Customer:

Reference: rework - RS1010

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580-041

F

101

0.00

\*101\*

DC

Memo

Document Control

WHITE LABELS ONLY - NO B/N

0.00

105

0.00

\*105\*

QC

Memo

Quality Control

RECORD SERIAL NUMBERS

0.00

C-FYZE 8/13/18

120

0.00

\*120\*

Skidtubes

Memo

Skidtubes

STEP 2 ON REPAIR SCHEME 1010

0.00

2 0 BE 13/07/18

# Work Order ID 104748

\*104748\*

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July-17-13 2:36:19 PM

Item ID: D205-634-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Replacement Skidtube Fits LH or RH  
 Start Date: 7/17/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/17/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference: rework - RS1010

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo STEP 3 ON RS1010	0.00 0.00				2			
140 *140* Skidtubes Skidtubes	QC5- Inspect part completeness to step on W/O  Memo STEP 4 ON RS1010	0.00 0.00				2			
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo SEP 5 ON RS1010	0.00 0.00				2			



# Work Order ID 104748

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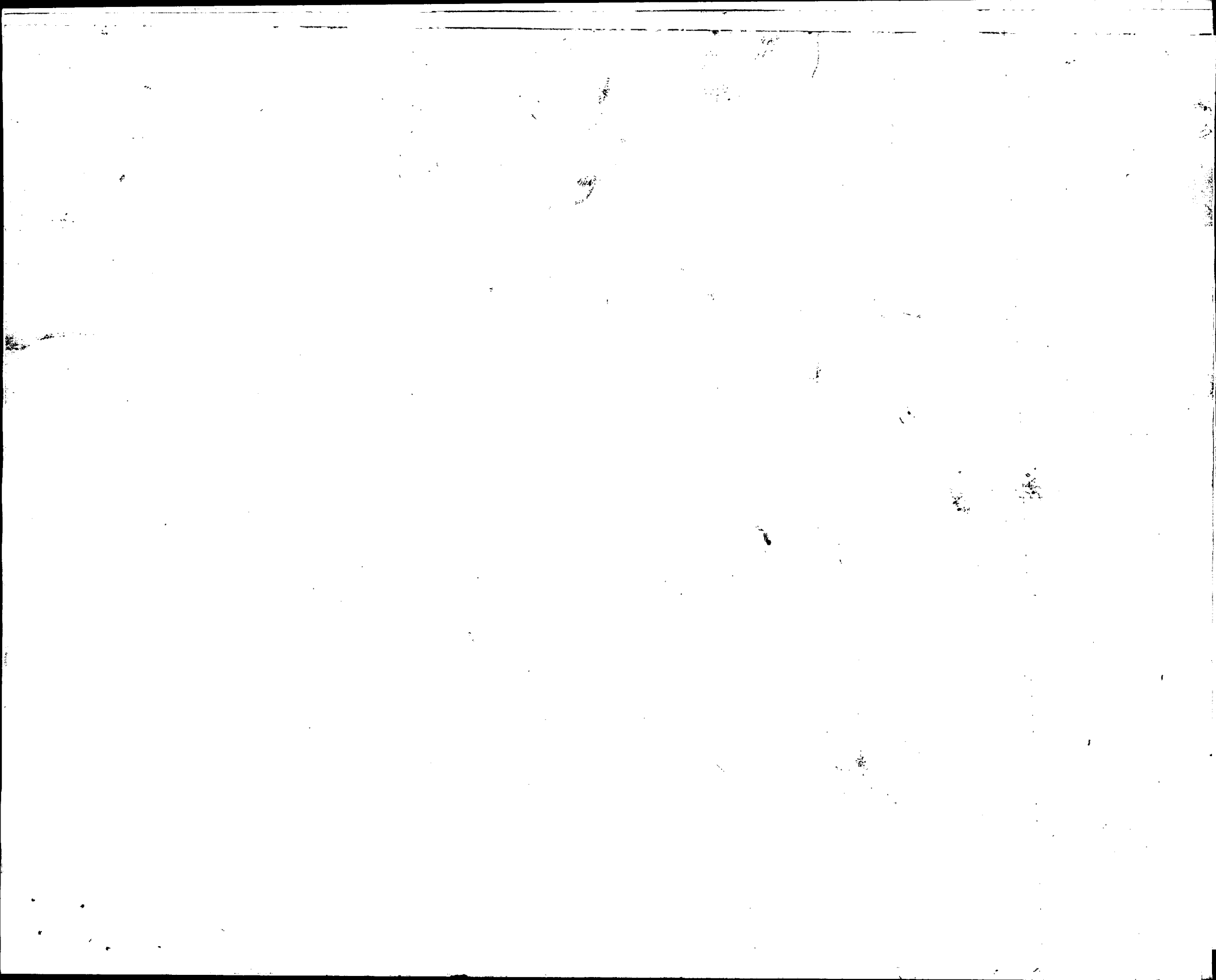
**\*104748\***

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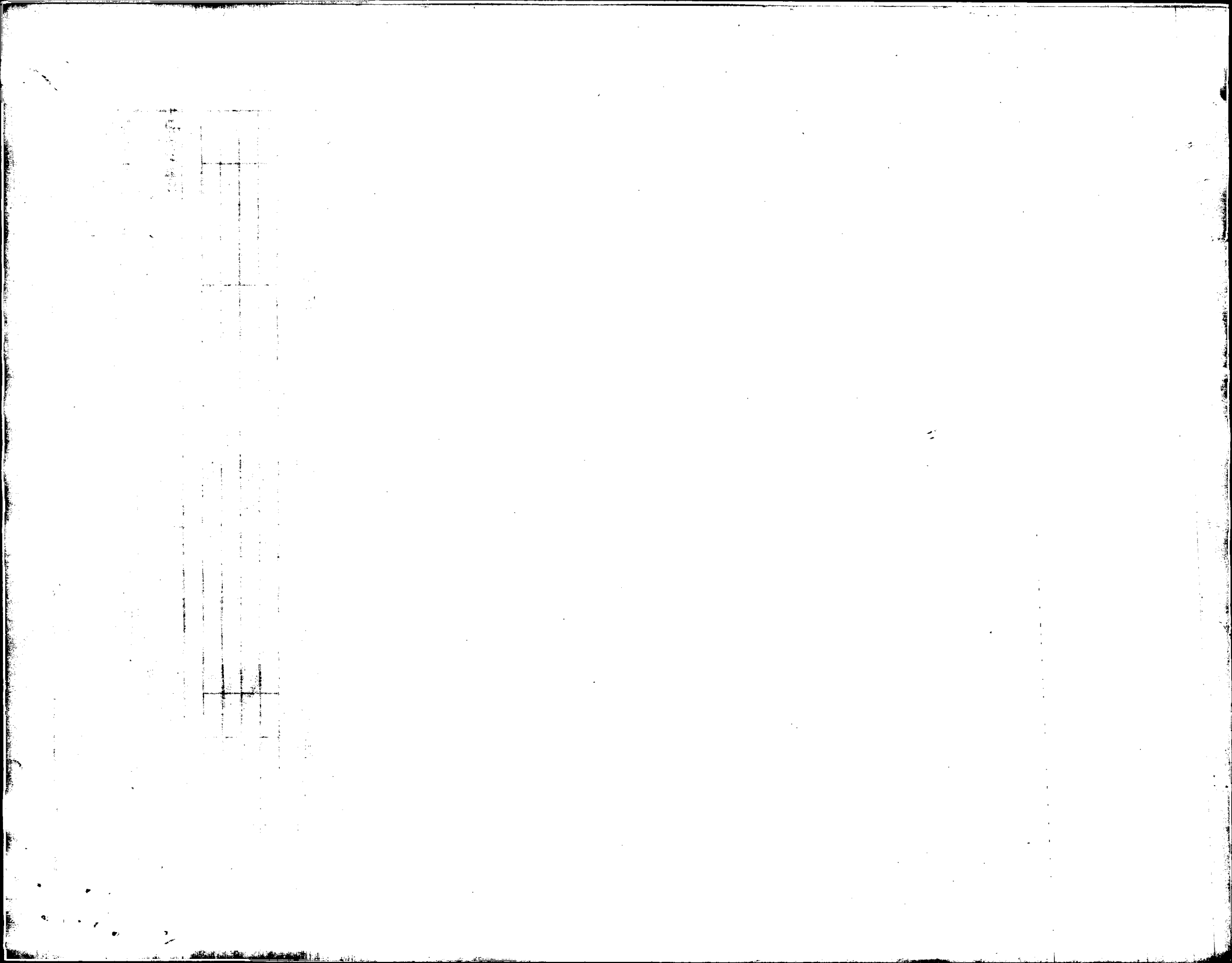
Item ID: D205-634-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube Fits LH or RH  
 Start Date: 7/17/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 7/17/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference: rework - RS1010

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 <b>*170*</b> HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo STEP 4A ON RS1010	0.00  0.00				2		2613-7-22	
210 <b>*210*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo STEP 5 ON RS1010	0.00  0.00							<del>S. Salazar</del> DAS 16 25 13/07/22
220 <b>*220*</b> Packaging Packaging Packaging	Packaging  Memo REPACKAGE - NO B/N REQUIRED SEE QC FOR PAPERWORK - NO ARC	0.00  0.00							(2x) 13-7-22







# **RA 111585 D205-634-011**

## **Re-work**

Received @ Dart July 16<sup>th</sup>, 2013  
Inspected @ Dart July 17<sup>th</sup>, 2013

CUSTOMER: CANADIAN HELICOPTERS  
CUSTOMER CONTACT: CHRIS WIERINGA  
SHIPPED FROM: LES CEDERS PQ, CANADA

### **Instructions for RA 111585 D205-634-011 C130710 & C130710A Re-work**

- Tubes are here for re working same re work scheme that David Duvall had original created for the previous re work
  - Remove all cross bolt spacers in the fwd. & aft saddles and the GHW areas
  - Remove the aft cap
  - Swage in new D4202-1 per DEO D2580-E-1
  - "clean" up only area around the saddles and GHW and re alodine in those locations
  - Reinstall aft cap with new sikaflex and with new AN3-5A bolts and NAS1149D0332J washers qty x 2 each of each skid tube
- 
- Both tubes need the same re-work work orders
  - Were removed from aircraft C-FYZE
  - Removal tags are with the RA

**Time Estimate** = 10 HOURS

**Departments Required:** Stores, Landing Gear & Finishing

**Pictures Attached** = NO

**QTY INSPECTED** = x1 D205-634-011 ????  
x1 D205-634-011 ????

**THIS INSTRUCTION SHEET MUST  
BE ATTACHED TO THE  
RESTOCKING WORK ORDER AT  
ALL TIMES!!!!**



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Page 1

Item ID: D205-634-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 7/17/13 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 7/17/13 Req'd Qty: 2.00 **\*2\***

Customer:

Reference: rework - RS1010

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580-041	F

101  
**\*101\***  
DC  
Document Control

Memo  
WHITE LABELS ONLY - NO B/N

0.00

MLS 13-07-22

2

105  
**\*105\***  
QC  
Quality Control

Memo  
RECORD SERIAL NUMBERS

0.00

120  
**\*120\***  
Skidtubes  
Skidtubes

Memo  
STEP 2 ON REPAIR SCHEME 1010

0.00

2 0 BE 13/07/18